

Work Order ID 48630

June 26, 2009 10:56:08 AM



Page 1

Item ID: D3393-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cam Lock Shaft

Start Date: 15/07/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3393

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA509 and Dwg D3393 (Machine D3393-3 as per Folio FA509 and Dwg D3393) Identify as D3393-3) IDeburr

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA509 and Dwg D3393

✓
~~5/10/09~~
~~5/10/09~~
✓

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Page 2

Item ID: D3393-3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

70546.30 20

Work Order ID 48630

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Page 3

Item ID: D3393-3

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Setup Start



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Start Date: 15/07/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 

0.00



Packaging

Memo

0.00

Packaging

216129
SQ

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

091071097H

mf
09-07-07

Picklist Print

Page 1

June 26, 2009 10:56:08 AM

Work Order ID: 48630

Parent Item: D3393-3RevA

Parent Item Name: Cam Lock Shaft



Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ M303R0.375  303 Round Bar 0.375"		Purchased	No			100	f	0.0000	2.4568 			

Date: Wednesday, 17/06/2009 11:32:44 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CAM LOCK SHAFT
Job Number :	48630		
Estimate Number :	10476		
P.O. Number :		Part Number :	D33933
This Issue :	17/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3393 REV A
First Issue :	///	Project Number :	N/A
Previous Run :	45364	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	24/06/2009
Written By :		Qty:	20
Checked & Approved By :		Um:	Each
Comment :	EsT A 05.02.18 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M303R0.375	303 Round Bar 0.375"
-----	------------	----------------------



Comment: Qty.: 0.1225 f(s)/Unit Total : 2.4507 f(s)

Material: AISI 303 SS Rod Ø0.375

(M303R0.375)

Batch: 1110379

mk 09/06/21

20

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA509 and Dwg D3393

Machine D3393-3 as per Folio FA509 and Dwg D3393

Identify as D3393-3

Deburr

mk 09/06/21

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 09/06/21

20

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA509 and Dwg D3393

SL 09/06/23

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL 09/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 11:32:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAM LOCK SHAFT

Job Number: 48630

Part Number: D33933

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 09/06/24 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BSW-30 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

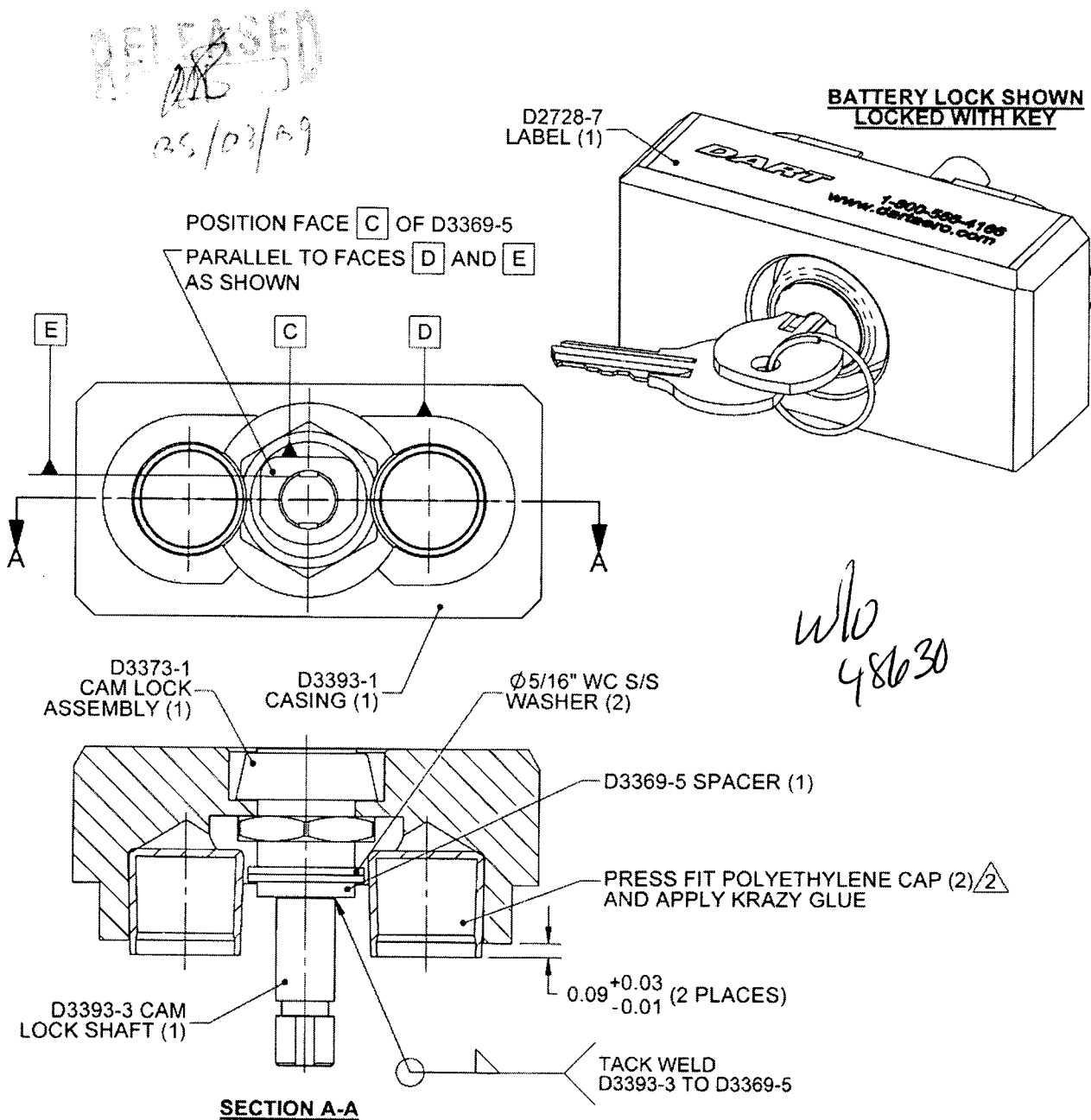
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	



D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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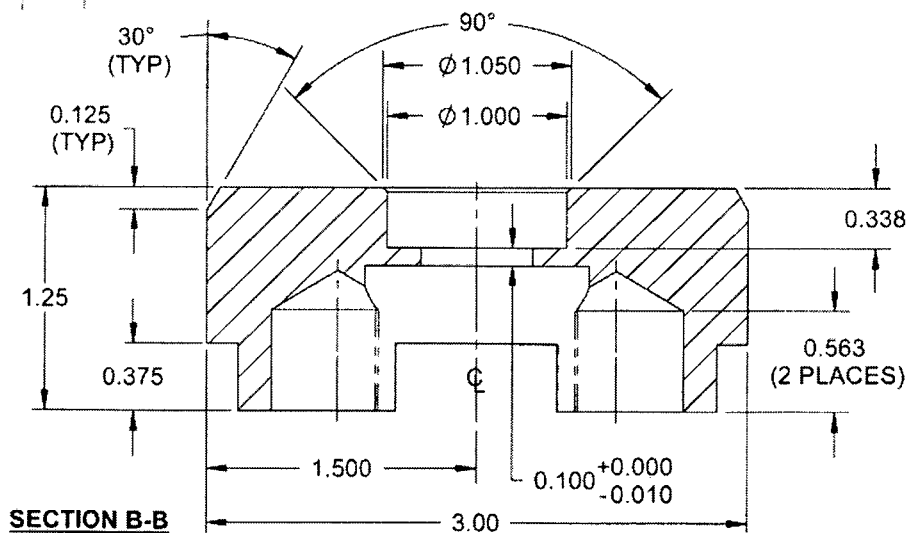
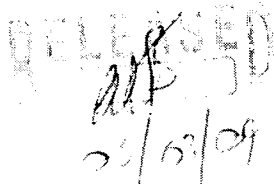
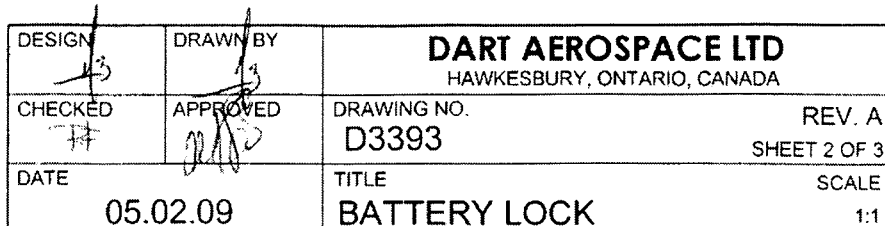
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

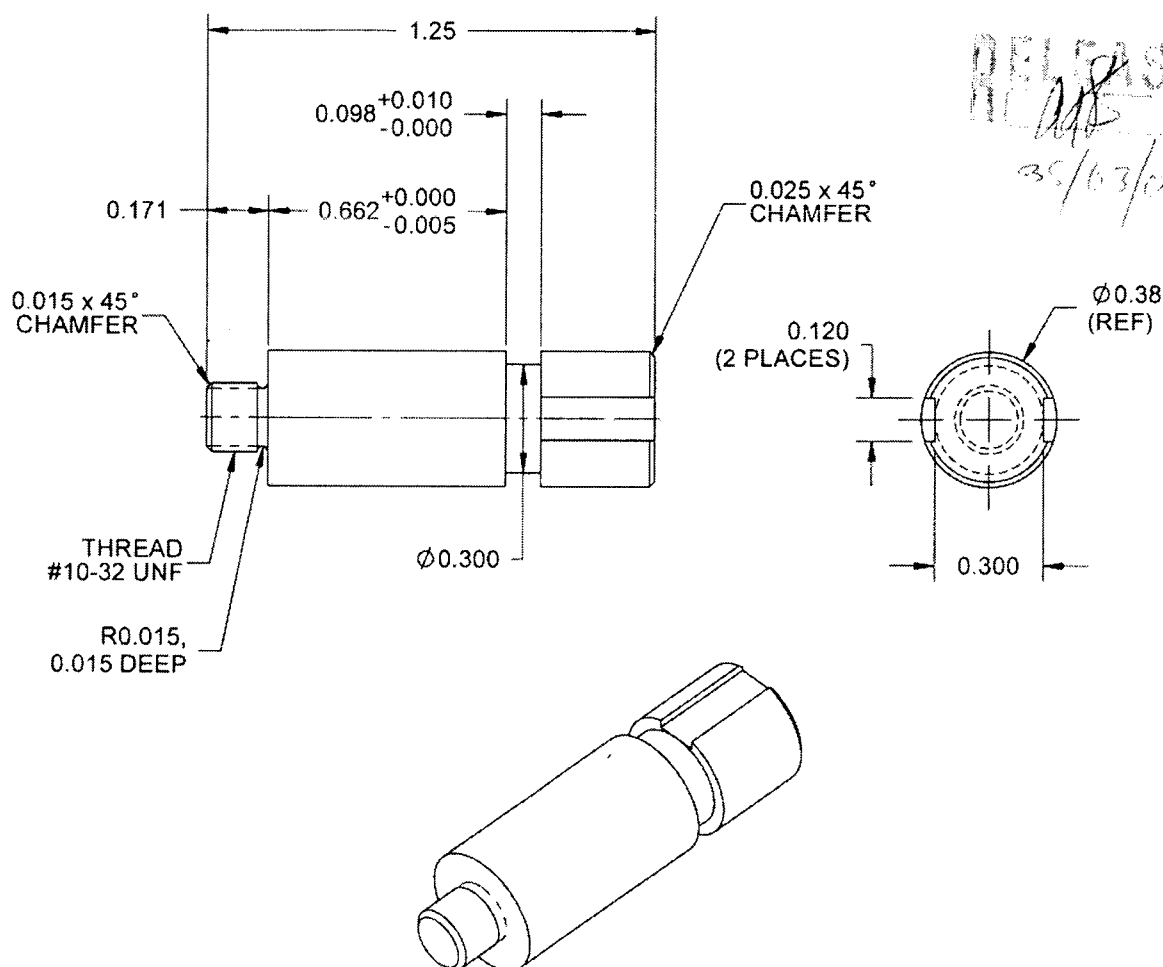
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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